

Date: Thursday, 4/12/2007 7:55:42 AM
 User: Eric Charbonneau

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FUEL PANEL SHEILD
Job Number :	31813		
Estimate Number :	12810		
P.O. Number :	N/A	Part Number :	D36091
This Issue :	4/12/2007	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D3609 UNDER REVIEW
First Issue :	N/A	Project Number :	N/A
Previous Run :	31512	Drawing Revision :	U/R
		Material :	N/A
Written By :	<u>E 07-04-12</u>	Due Date :	4/13/2007
Checked & Approved By :		Qty:	1 Um: Each
Comment :	Est Rev:A New Issue 07-03-26 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S22GA	304/316 .032 Sheet
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Comment: Qty.: 0.5256 sf(s)/Unit Total : 0.5256 sf(s)

304/316 .032 Sheet

Batch: m102159ml 07 04 12

①

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3609

Dwg Rev: U/RProg Rev: b/Rml 07 04 12

②

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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ml 07 04 12

③

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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ml 07 04 12**ENGINEERING APPROVAL****Comment:** SECOND CHECKml 07/04/12

④

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FOR ENGINEERING USE ONLY00071

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PANEL SHEILD

Job Number: 31813

Part Number: D36091

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

1907104/13

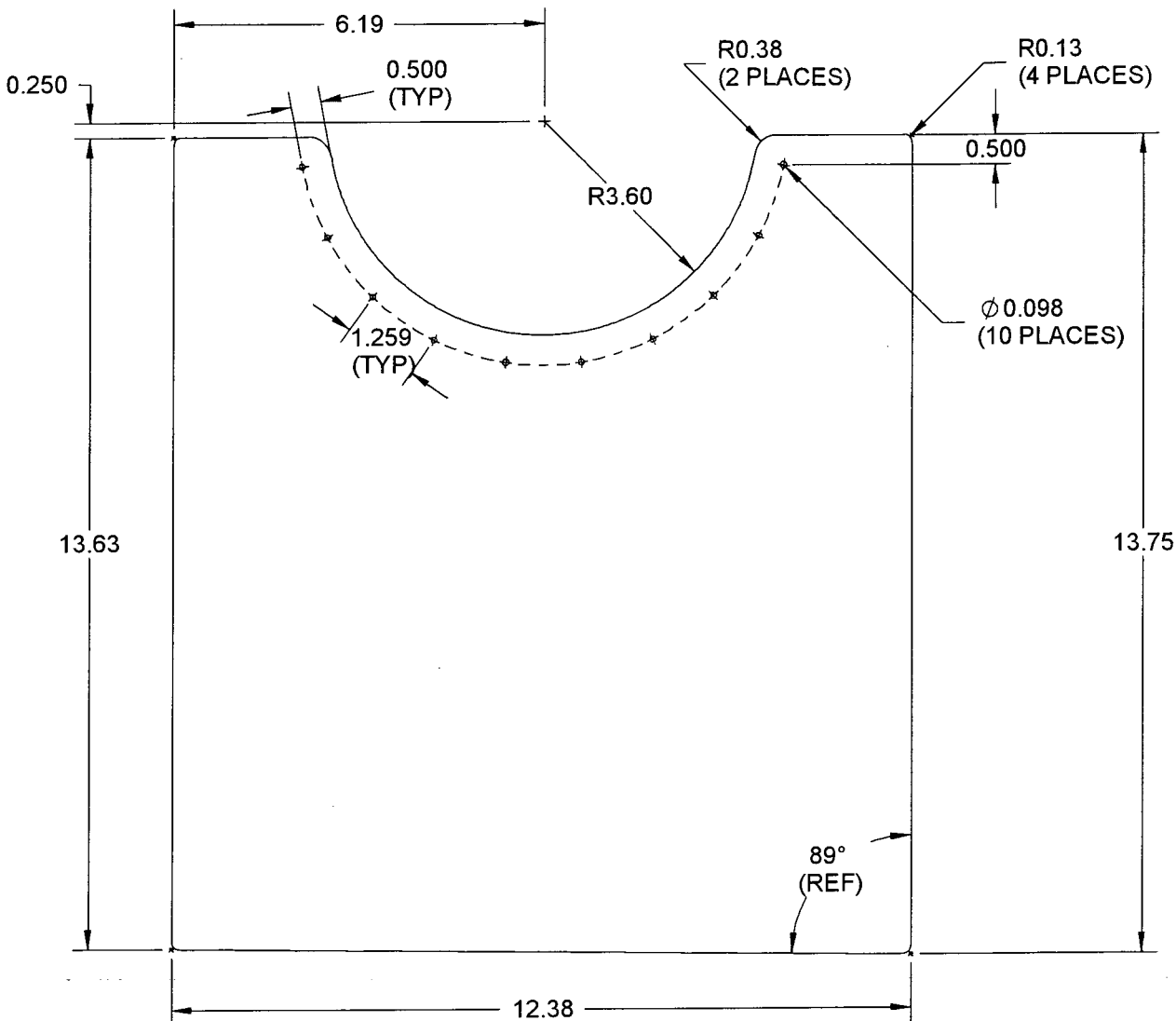
Job Completion



in 8704.13

PRELIMINARY ISSUE
07.04.11

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3609	REV. A SHEET 1 OF 1
DATE 07.04.11		TITLE FUEL PANEL SHIELD	SCALE 1:3
REV	DATE	DESCRIPTION	
A	07.04.11	NEW ISSUE	



D3609-1 DOUBLER

NOTES:

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 22 GAUGE (0.032 THICK)
PER AMS 5513 OR AMS 5524 (REF. DART SPEC. M304S24GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) IDENTIFY WITH DART P/N "D3609-1" USING FINE POINT PERMANENT INK MARKER
 - 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
 - 7) PART IS SYMMETRIC ABOUT ϕ

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DART AEROSPACE LTD	Work Order: 31813
Description: Fuel Panel Shield	Part Number: D3609-1
Inspection Dwg: D3609 Rev: U/R	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☒ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 12.38	+/- 0.030	12.375	✓		Measuring tape	
B 13.63	+/- 0.030	13.600	✓		Measuring tape	
C 13.75	+/- 0.030	13.75	✓		Measuring tape	
D ϕ 0.098	+0.004-0.001	0.098	✓		vern	
E 0.500	+/- 0.010	0.507	✓		vern	
F 1.259	+/- 0.010	1.266	✓		vern	
G 0.500	+/- 0.010	0.508	✓		vern	
H						
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J						
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V						
W						
X						
Y						

Measured by: <i>MA MA</i>
Date: 07/04/12

Audited by: <i>[Signature]</i>
Date: 07/04/12

Prototype Approval: <i>[Signature]</i>
Date: 07.04.12

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	